

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-004252**Date Inspected:** 25-Sep-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1500**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang, Jiang Jian Fei**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** 89M tower mockup, tower skin assemblies, etc.**Summary of Items Observed:****89M Tower Mockup**

Caltrans Quality Assurance Inspector George Goulet (QA Inspector) observed electric heating pad wires leading under thermal blankets. QA Inspector was informed at 1030 hours by ABF QC Kim Xiao (ABF QC) that ZPMC finished SMAW the fit lug to diaphragm at 0930 hours. ABF QC then showed QA Inspector the post heat record and a decrease in temperature of 29°C for the first hour after finish of welding.

Tower shop - Bay 1

QA Inspector randomly observed approximately 55 ZPMC workers performing the following: grinding of cover pass on SSD1 – skin E assembly; flame heat straightening of stiffeners and electric preheating of plates; SMAW of tacks on weld SSD1-SA61G/G-3. Also present in this bay were ZPMC CWI Li Yang and ABF QC's Yang Yi Heng and Zhang Qing Jian. Items observed appeared to comply with project specifications.

Tower shop - Bay 2

QA Inspector randomly observed approximately 50 ZPMC workers performing the following: grinding of cover pass on ESD1-skin D assembly; grinding of tacks between diaphragm plates and ESD1-skin A assembly; SAW of skin plate butt welds. QA Inspector, QA Inspector Greg Bertlesman (QA Inspector 2), and QA Inspector Ray Lara (QA Inspector 3) were assigned by QA Task Leader Robert Cuellar to perform final MT and VT on the longitudinal stiffener to skin plate welds on ESD1-skin A assembly. Upon arrival at the ESD1-skin A assembly, QA Inspector 2 reported that he was unable to locate any notations of ZPMC or ABF final MT or VT. QA Inspector 2 reported to QA Inspector that he was informed by ABF QC C. K. Chan that ABF had no record of QC final MT or VT having been performed. Also present in this bay were ZPMC CWI Jiang Jian Fei as well as ABF

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QC Zhang Da Ming. Items observed appeared to comply with project specifications.

Heavy Duty Machine Shop - Bay 3

QA Inspector randomly observed 3 ZPMC workers in this bay. There were 12 full size panels and several unidentified deck plates in various stages of butt welding present in the bay. It appeared to QA Inspector that ZPMC personnel had been performing deck plate repairs per Welding Repair Report B-WR955. Items observed appeared to comply with project specifications.

Summary of Conversations:

As noted above in Summary.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Joshua Ishibashi, 136-6471-0411, who represents the Office of Structural Materials for your project.

Inspected By:	Goulet,George	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
